

Ship Friday 13/07

Work Order ID 87747

87747

Page 1

July-11-12 8:23:07 AM

Item ID: D4672-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Blanking Plate

Stop *NS2*

Start Date: 11/07/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 25/07/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 12/07/11

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4672-1

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D4672

Dwg Rev: A

Prog Rev: 17

2-Deburr as required

8 0 Jm 12-7-12

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

8 0 Jm 12-7-12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 25/07/2012 Req'd Qty: 8.00

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location <u>5241A</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

DAS
16
9-8
12/07/13

(X)

Sx

SP
12-7-14

12/7/18

MLJ 12/07/16

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Pieclist Print

July-11-12 8:23:12 AM

Page 1

Work Order ID: 87747

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Parent Item: D4672-3

D4672-3

Parent Item Name: Blanking Plate

Start Date: 11/07/2012

Required Date: 25/07/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 12-07-10 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S20GA

Purchased

No

sf

297.8693

1.684211

M304S20GA

**

1.75

304/316 .040 Sheet

Jm 12-7-12

Location

Loc Qty

Loc Code

001

52.4914105

121192

52.4914105

MAT020

245.377922

117933

27.3442

118400

5.3723

118964

23.2

119346

24.8

121380

49.761422

121901

114.9

121901

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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 87777 ML5
 12/07/11

D4672-3 BLANKING PLATE

D4672-1 BLANKING PLATE

RELEASED
 2012-07-10
 4P ELM 12-611

A		NEW ISSUE		MB	12.06.13
REV.		DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN					
CHECKED		DRAWING NO.	REV. A		
MFG. APPR.		D4672	SHEET 1 OF 2		
APPROVED		TITLE	SCALE		
DE APPR.		BLANKING PLATE	NTS		
DATE	12.06.13	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON OR ENTITY WITHOUT PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

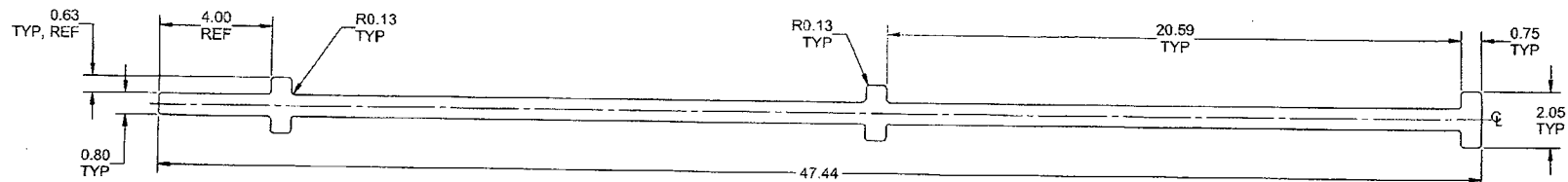
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

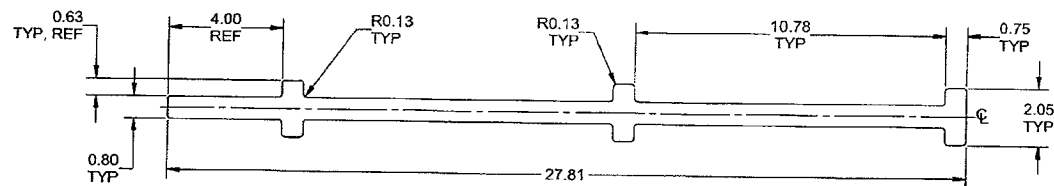
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87747



D4672-1 BLANKING PLATE



D4672-3 BLANKING PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED 2B FINISH PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 REF DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4672-X" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: D4672-1 = 0.47 lbs; D4672-3 = 0.29 lbs
- 8) SYMMETRY: ABOUT CENTERLINE OF PART

RELEASED
2012-07-10
4 ECH 12-64

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4672
MFG. APPR.		REV. A SHEET 2 OF 2
APPROVED		TITLE BLANKING PLATE
DE APPR.		SCALE NTS
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FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	